

ASAP

11.10.09

Work Order ID 74050

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D3805-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 9/21/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3805

B

11.10.09
SCM-640

0.00

100



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3805

Dwg Rev: PB1

Prog Rev: PB1

2-Deburr if necessary

B11-9-21

20

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

B11-9-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74050

Wednesday, September 21, 2011 8:51:12 AM



Page 2

Item ID: D3805-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 9/21/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspector to PB1



QC

Memo

0.00

Quality Control

Day only
8/10/12 (20) *auto*

130

0.00



Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3805 using Jigs DT8261 and DT8326

SB 11/09/12 (20)

140

QC5- Inspect part completeness to step on W/O

0.00 - inspector to PB1



QC

Memo

0.00

Quality Control

Day only
8/10/12 (20) *auto*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74050

Wednesday, September 21, 2011 8:51:12 AM

Page 3

Item ID: D3805-5

Accept

Revision ID:

Item Name: Plate

Start Date: 9/21/2011 Start Qty: 20.00

Required Date: 9/29/2011 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: *W/A*

0.00

Packaging

Memo

0.00

Packaging

EL 11-9-28

(220)

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/10/4

ME 11-09-28

POSITIVE RECALL

EFFECTIVE *11-09-21*

AUTH *U*

RELEASED *11-09-21*

DATE *11-10-09*

BEN 11-640

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 21, 2011 8:51:09 AM

Page 1

Work Order ID: 74050

Parent Item: D3805-5

Parent Item Name: Plate



Start Date: 9/21/2011

Required Date: 9/29/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	205.5550	1.587	33.41053			



304/316 .050 Sheet



11-9-21

Location

Loc Qty

Loc Code

MAT020

64.655

113062

0.155

116979

64.5

MAT021

140.9

118217

140.9

118217

CD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

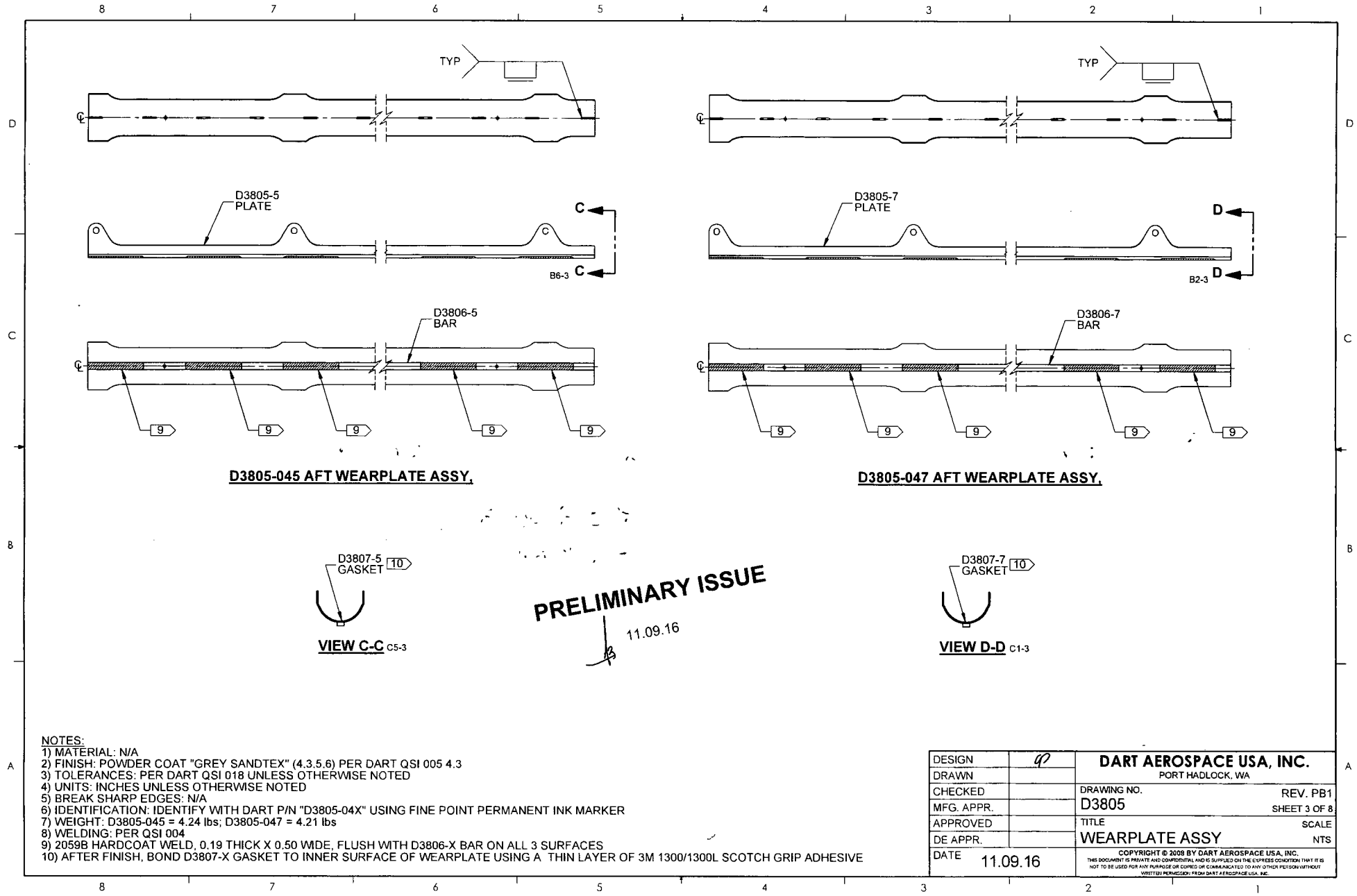
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3805-045 AFT WEARPLATE ASSY.

D3805-047 AFT WEARPLATE ASSY.

D3807-5
GASKET 10

VIEW C-C C5-3

D3807-7
GASKET 10

VIEW D-D C1-3

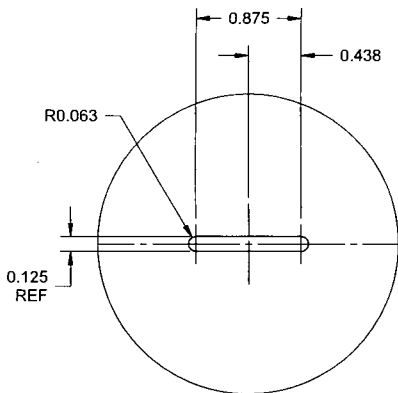
PRELIMINARY ISSUE

11.09.16

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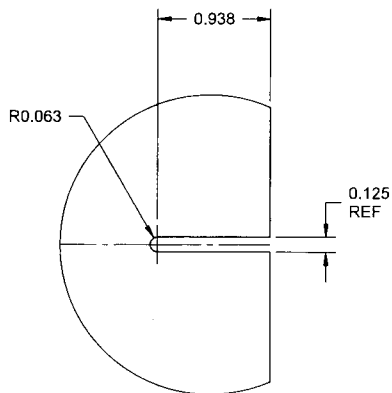
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	47	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D3805	SHEET 3 OF 8
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DE APPR.		WEARPLATE ASSY	NTS
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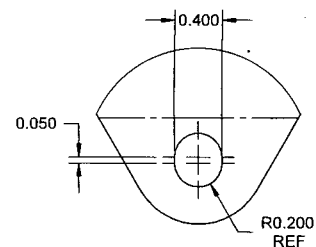
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SCALE 4X

C5-4
C5-5
C4-6
C4-7



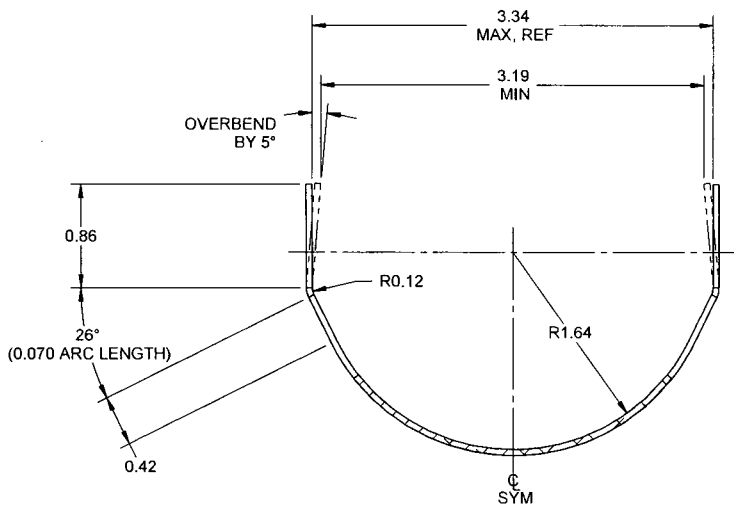
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C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



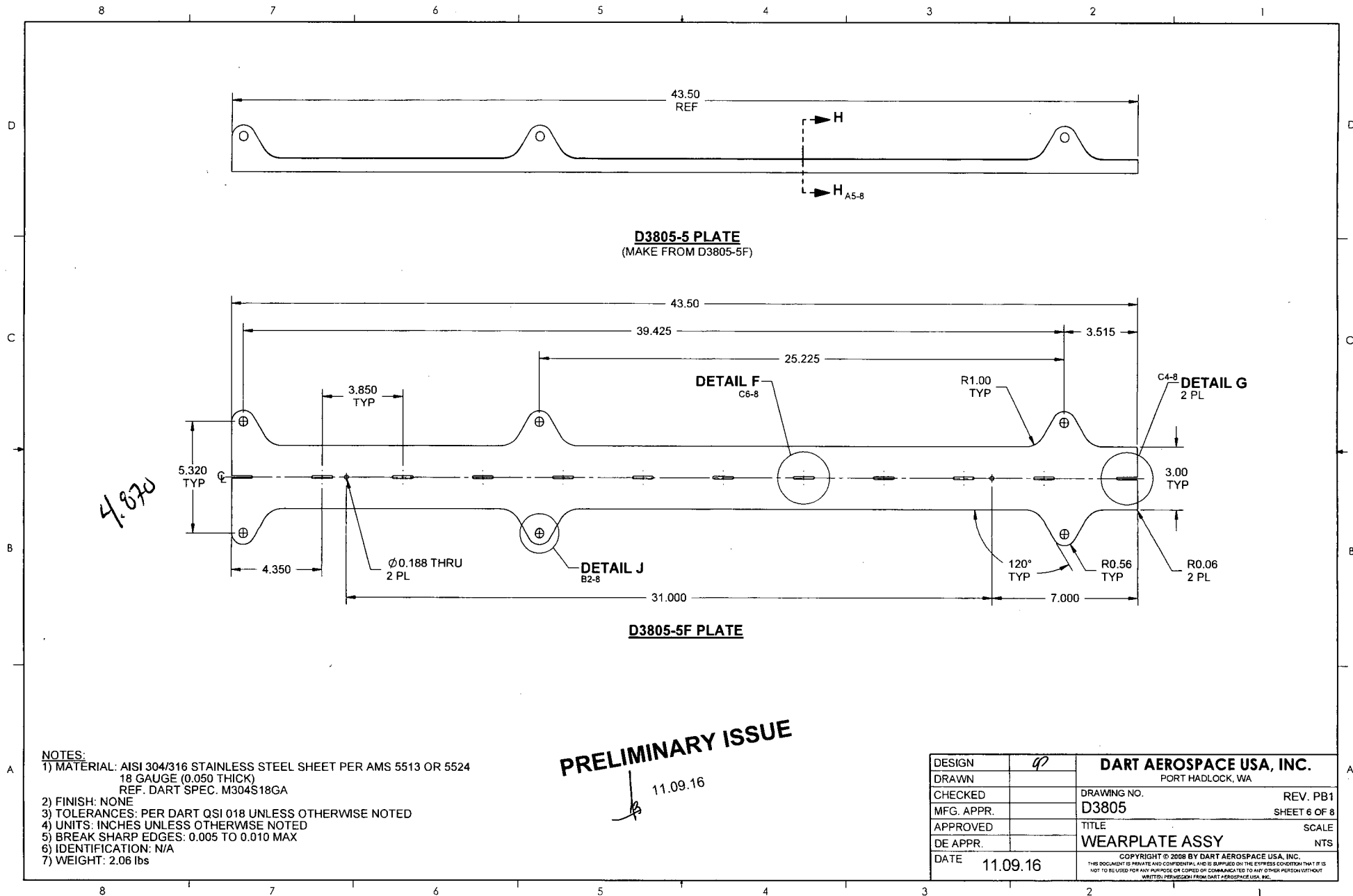
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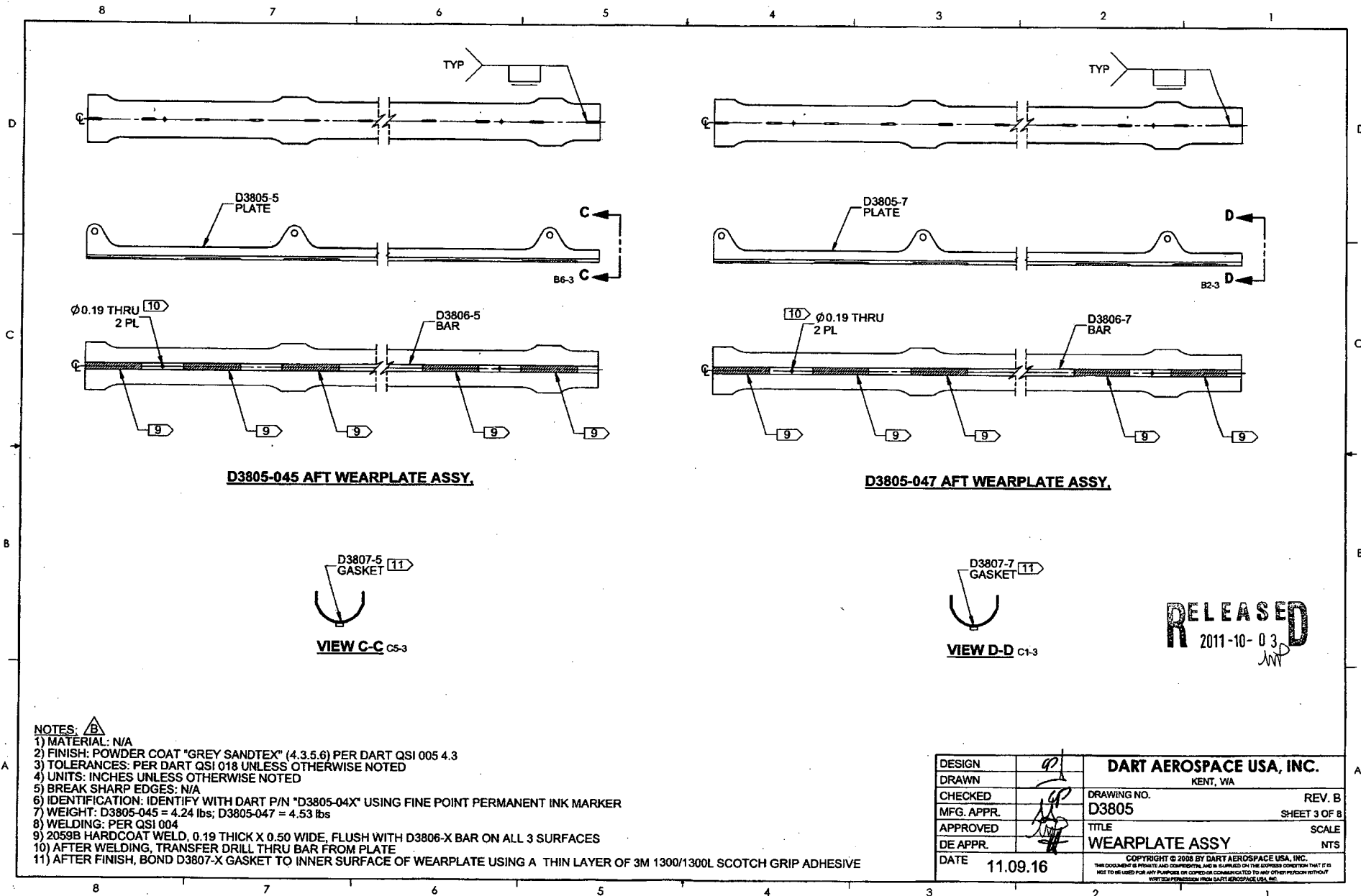
D3-4
D3-5
D3-6
D3-7

PRELIMINARY ISSUE

11.09.16

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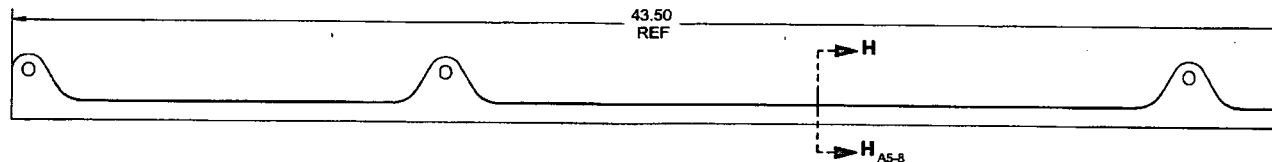


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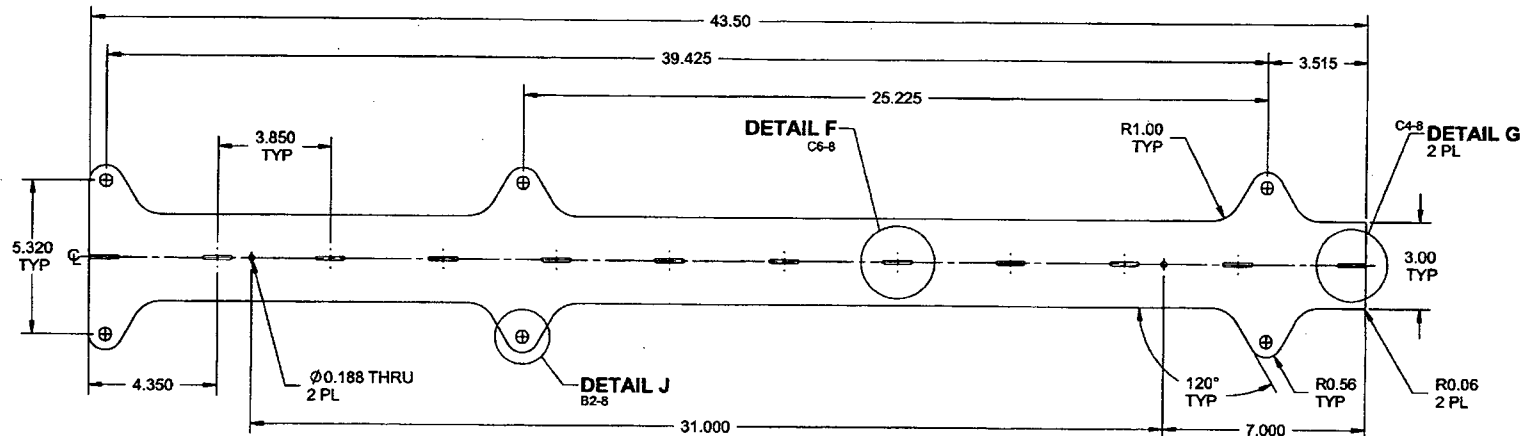
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
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MFG. APPR.		D3805	SHEET 3 OF 8
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DE APPR.		WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



D3805-5 PLATE
(MAKE FROM D3805-SF)



D3805-5F PLATE

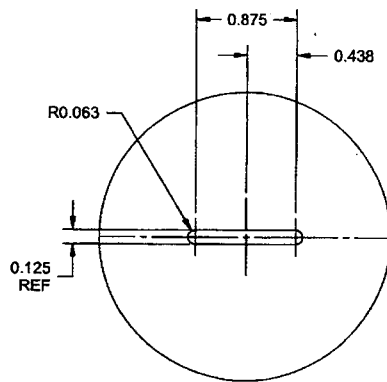
RELEASED
2011-10-03

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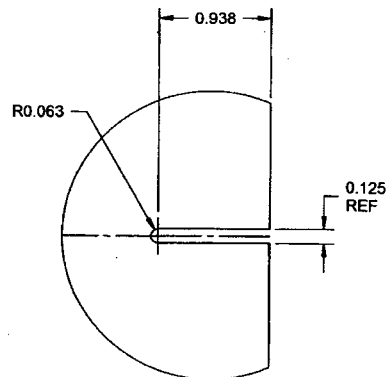
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

DESIGN		DART AEROSPACE USA, INC.	
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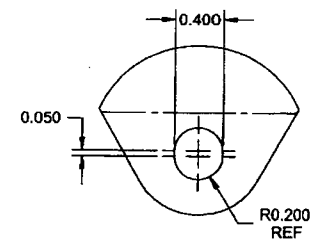
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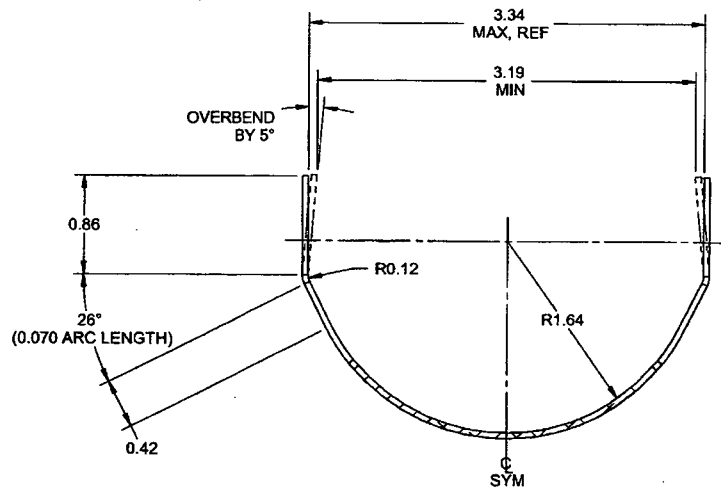
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SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

RELEASED
2011-10-02
JW

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